

Thursday, 2/23/2006 10:23:56 AM
User: Kim Johnston

Process Sheet

Iphit

Customer : CU-D-001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
Job Number : 25920-2
Estimate Number : 1033-
P.O. Number : N/A Part Number : D2804042
This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D2804 REV B
Prsh Rev. : NC Project Number : N/A
First Issue : N/A Type : R & D SM/MED FAB Drawing Revision : B
Previous Rev. : 23627 Material : N/A
Written By : SEE COMMENT BELOW Due Date : 3/22/2006 Qty: 10
Checked & Approved By : 06.02.23 Um: 2
Comment : Est F 05/03/30 MS21043-3 was MS21042L3 KJ/JLM Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D28042 STA 155 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

STA 155 Bracket

Pick:

Qty	Part Number	Description	Batch
1	D2804-2	Bracket	B25714 (8) B25930

SB 06/03/15 10

2.0 D28052 Stop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Stop

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	8 (B 14244) B24620 B21306 (8)

Batch

SB 06/03/15

10

3.0 D2809 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B25959

Batch

SB 06/03/20

10

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2804

SB 06/03/15 10

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



06-03-15

10

Comment: INSPECT WORK TO CURRENT STEP

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/03/17

10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



06-03-20

10

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	<i>M17944</i>

10

9.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	<i>M19099</i>

10

10.0

NAS1515H3

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	<i>M17944</i>

A/R LPS-3

Corrosion Spray

M17045

40

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25920

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804

2-Assemble as per Dwg D2804.

SAD

06/03/20

(10)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 159

CZ 06/03/21

(10)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/03/23 (10)

Job Completion



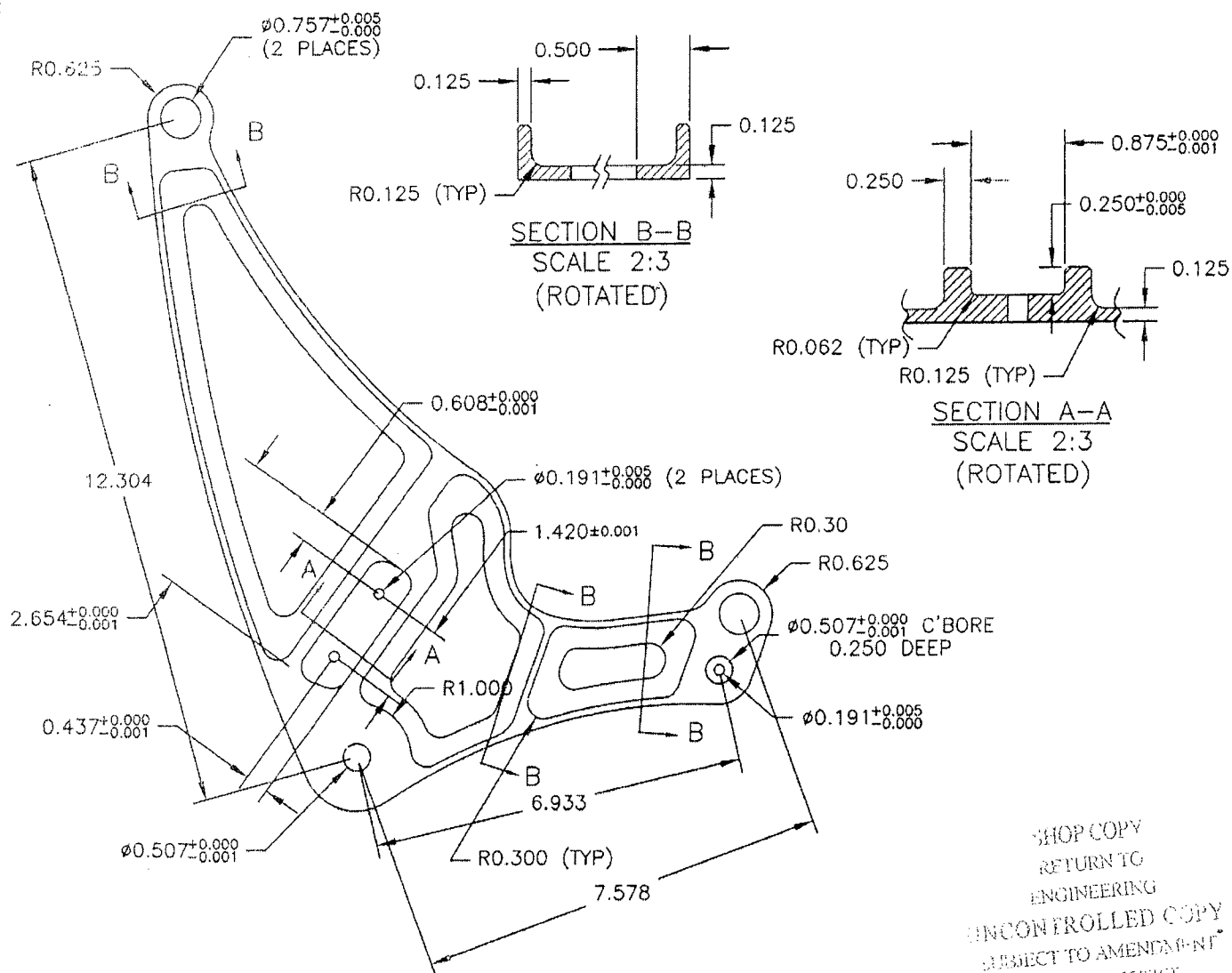
U 06-03-22



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B
DATE	04.11.22	TITLE	STA 155 BRACKET	SHEET 1 OF 2
				SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05-03-11



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WITHOUT NOTICE
WORK ORDER
NO. 25920

D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

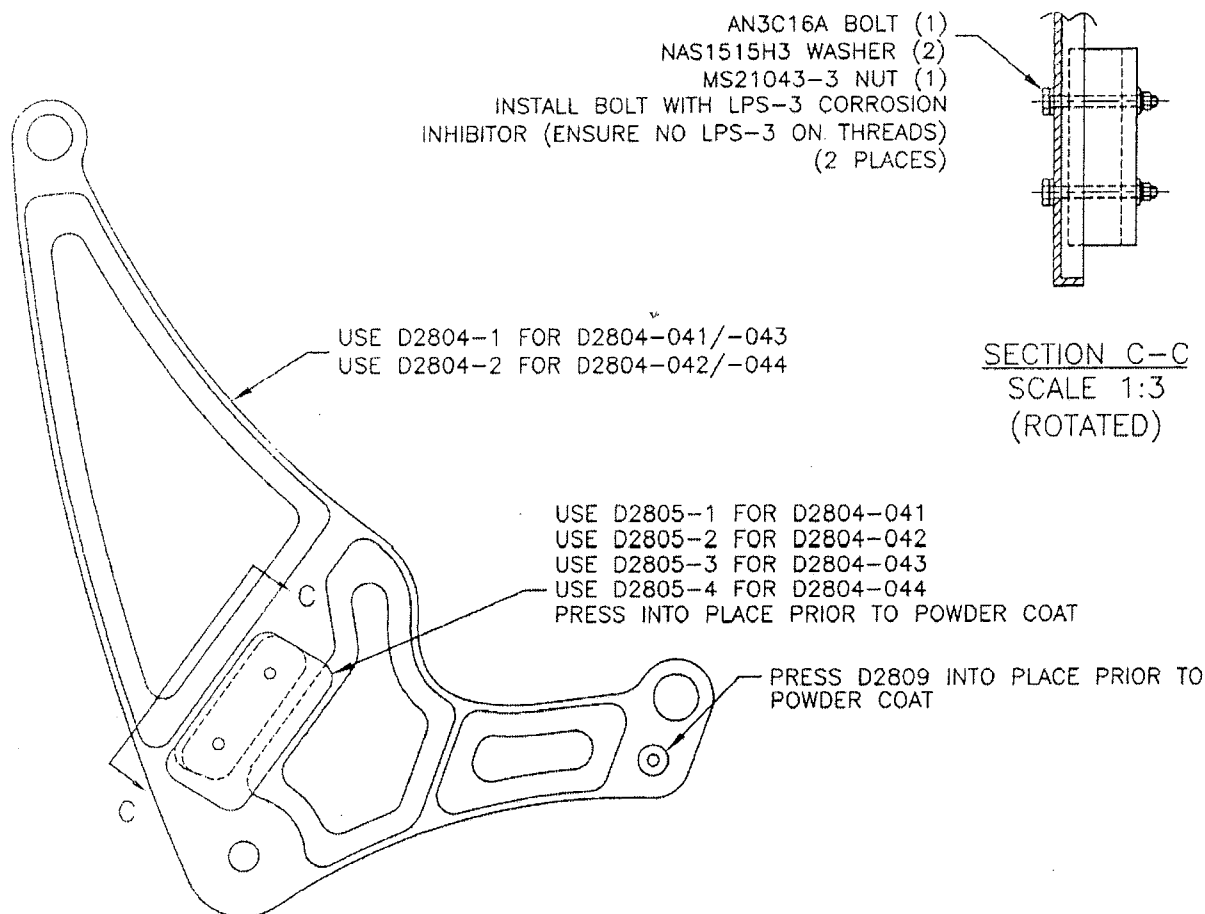
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. B
DATE	04.11.22	TITLE	STA 155 BRACKET	SHEET 2 OF 2
				SCALE 1:3



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WORK ORDER

REF 25920

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3


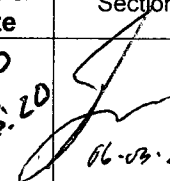

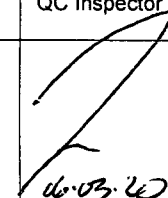
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LP Date: 06/03/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.03.20	3	1x D2809 was crushed during Press fitting.		Place D2809 in vise, and remove. Scrap and replace.	SAD 06.03.20	 06.03.20		 06.03.20

NOTE: Date & initial all entries